

Date: Tuesday, 1/9/2007 4:06:43 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	: 30214	Part Number	: D2573		
Estimate Number	: 10533	Drawing Number	: D2573 REV E		
P.O. Number	: N/A	Project Number	: N/A		
This Issue	: 1/9/2007	Drawing Revision	: E		
Prsht Rev.	: NC	Material	: N/A		
First Issue	: N/A	Due Date	: 1/30/2007	Qty:	12 Um: Each
Previous Run	: 30096				
Written By	: <i>[Signature]</i>				
Checked & Approved By	: <i>[Signature]</i> 07.01.09				
Comment	: Est: 1 As Per RevE 06-01-27 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	7075-T7351 8.25X7.75X2.5	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: <i>B25355</i>	<i>v12 En 07/01/14 J.F.</i>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <i>B25355</i> Double check by: <i>J.F.</i>	<i>En / J.F. 02/01/18</i>
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	<i>o</i>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574	<i>J.F. 07/01/18</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>En / J.F. 07/01/18</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/01/25
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/9/2007 4:06:44 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 30214

Part Number: D2573

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

07/01/22 12

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HL/

07/01/22 12

7.0 POWDER COATING POWDER COATING



M1103141

12X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-h/y

07/01/24

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PL/1/24 (22)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5464

07/01/24 12X

10.0 QC21 FINAL INSPECTION/W/O RELEASE



12

Comment: FINAL INSPECTION/W/O RELEASE

07/01/25

Job Completion



U.D.01.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	30214
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.440	.439	.440	.439		
B	1.745	1.755		1.751	1.749	1.751	1.749		
C	3.495	3.505		3.500	3.498	3.501	3.498		
D	1.745	1.755		1.751	1.750	1.751	1.750		
E	7.990	8.010		7.999	8.000	8.000	8.003		
F	0.490	0.510		.503	.503	.500	.500		
G	0.257	0.262	DT8683	.258	.260	.254	.257		
H	0.375	0.380	DT8684	.376	.374	.376	.375		
I	0.490	0.510		.504	.504	.496	.504		
J	1.174	1.184		1.180	1.180	1.178	1.178		
K	0.558	0.578		.570	.570	.559	.559		
L	1.174	1.184		1.180	1.180	1.178	1.178		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.125	4.125	4.126	4.125		
P	0.115	0.135		.127	.127	.126	.125		
Q	0.115	0.135		.135	.135	.135	.125		
R	0.240	0.260		.251	.251	.250	.250		
S	0.115	0.135		.128	.128	.126	.128		
T	0.178	0.198		R.188	R.188	R.188	R.188		
U	3.210	3.250		3.232	3.232	3.233	3.229		
V	0.230	0.250		.246	.246	.241	.245		
W	0.115	0.135		.125	.125	.127	.125		
X	0.308	0.313		.310	.310	.312	.310		
Y	0.760	0.765		.760	.760	.763	.760		
Z	0.352	0.372		.370	.370	.362	.370		
AA	0.470	0.530		R.500	R.500	R.500	.500		
AB	0.615	0.635		.631	.625	.634	.625		
AC	0.053	0.073		R.063	R.063	R.063	.063		
AD	0.240	0.260		.254	.254	.248	.250		
AE	1.500	1.520		1.517	1.510	1.511	1.510		
AF	0.115	0.135		.135	.135	.135	.120		
AG	0.240	0.280		.255	.255	.260	.257		
AH	0.240	0.260		.254	.254	.251	.254		
AI	2.000	2.020		2.001	2.002	2.001	2.000		
AJ	0.023	0.043		.021	.021	.025	.025		

Accept/Reject

Measured by:	J.F. / S.F. (4)	Audited by:	✓
Date:	07/01/18	Date:	07/01/22

Rev.	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	✓ ✓

DART AEROSPACE LTD				Work Order:	30214
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	Ø, 440	Ø, 440"	Ø, 440"	Ø, 440"		
B	1.745	1.755		1,751	1,751	1,751"	1,751"		
C	3.495	3.505		3,500	3,500	3,500"	3,500"		
D	1.745	1.755		1,751	1,751"	1,751"	1,751"		
E	7.990	8.010		8,001"	7,999"	8,001"	8,002"		
F	0.490	0.510		500	502"	503	501"		
G	0.257	0.262	DT8683	Ø, 260"	Ø, 260"	Ø, 260"	Ø, 260"		
H	0.375	0.380	DT8684	Ø, 376"	Ø, 376"	Ø, 376"	Ø, 376"		
I	0.490	0.510		504"	503"	504"	505"		
J	1.174	1.184		1,181"	1,181"	1,181"	1,181"		
K	0.558	0.578		571"	574"	571"	571"		
L	1.174	1.184		1,181"	1,181"	1,181"	1,181"		
M	1.365	1.375		1,372"	1,372	1,372"	1,372"		
N	2.495	2.505		2,500"	2,500	2,500"	2,500"		
O	4.119	4.129		4,124"	4,124"	4,124"	4,124"		
P	0.115	0.135		127"	127"	128"	128"		
Q	0.115	0.135		135"	135"	135"	135"		
R	0.240	0.260		251"	251"	251"	251"		
S	0.115	0.135		125"	129"	126"	126"		
T	0.178	0.198		R, 188"	R, 188"	R, 188"	R, 188"		
U	3.210	3.250		3,233"	3,233"	3,233"	3,233"		
V	0.230	0.250		242"	240"	240"	241"		
W	0.115	0.135		126"	124"	127"	125"		
X	0.308	0.313		378"	312"	312"	372"		
Y	0.760	0.765		762"	763"	763"	763"		
Z	0.352	0.372		365"	370"	370"	370"		
AA	0.470	0.530		R, 500"	R, 500"	R, 500"	R, 500"		
AB	0.615	0.635		632"	634"	634"	632"		
AC	0.053	0.073		R, 063"	R, 063"	R, 063"	R, 063"		
AD	0.240	0.260		1248"	244"	1248"	1244"		
AE	1.500	1.520		1511	1,514"	1,512"	1,513"		
AF	0.115	0.135		135"	121"	121"	121"		
AG	0.240	0.280		255"	267"	267"	270"		
AH	0.240	0.260		251"	251"	251"	252"		
AI	2.000	2.020		2,003	2,007"	2,002"	2,003"		
AJ	0.023	0.043		,025	,025	,025	,025		
Accept/Reject									

Measured by:	JF-	Audited by:	JML
Date:	07/01/19	Date:	07/01/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JML

DART AEROSPACE LTD				Work Order:	30214
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

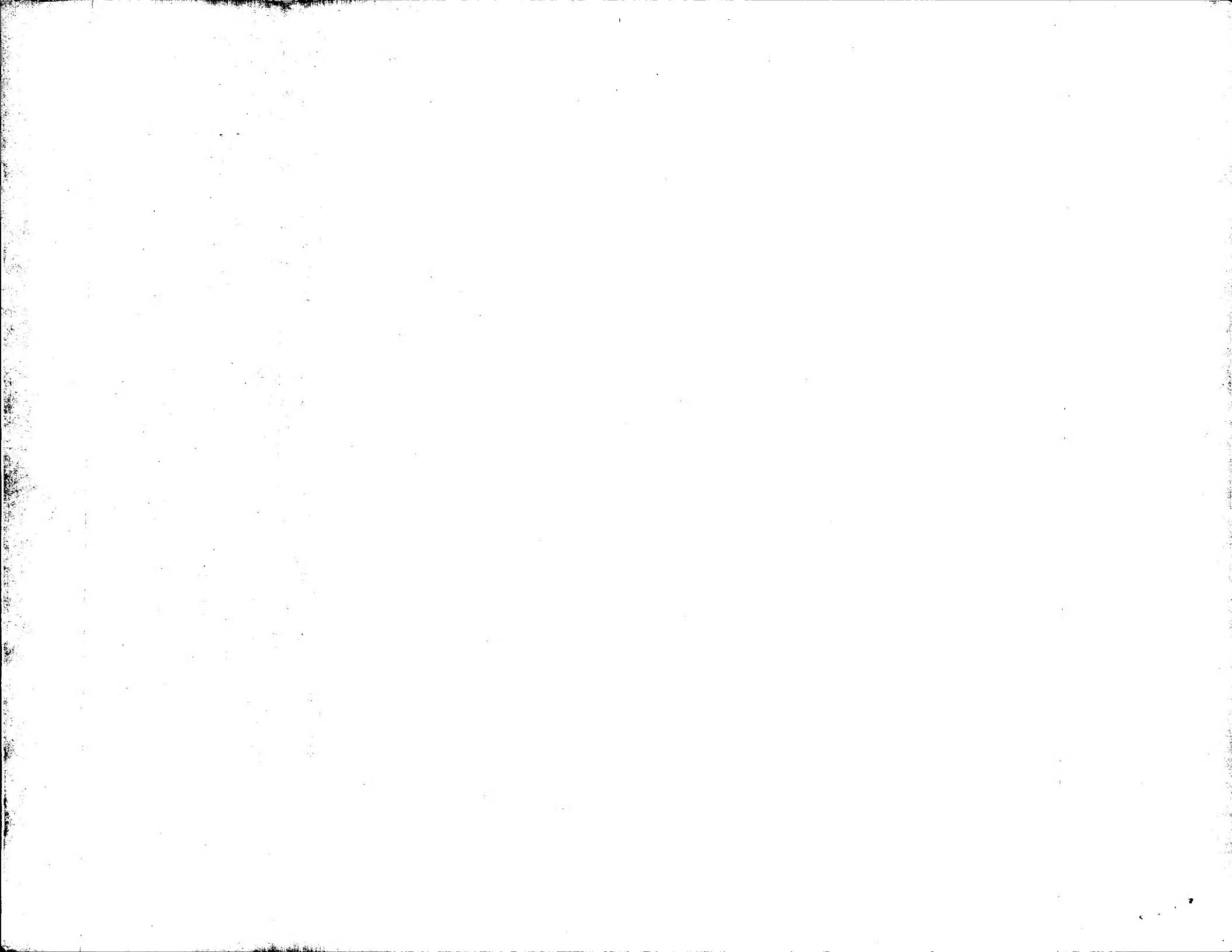
Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

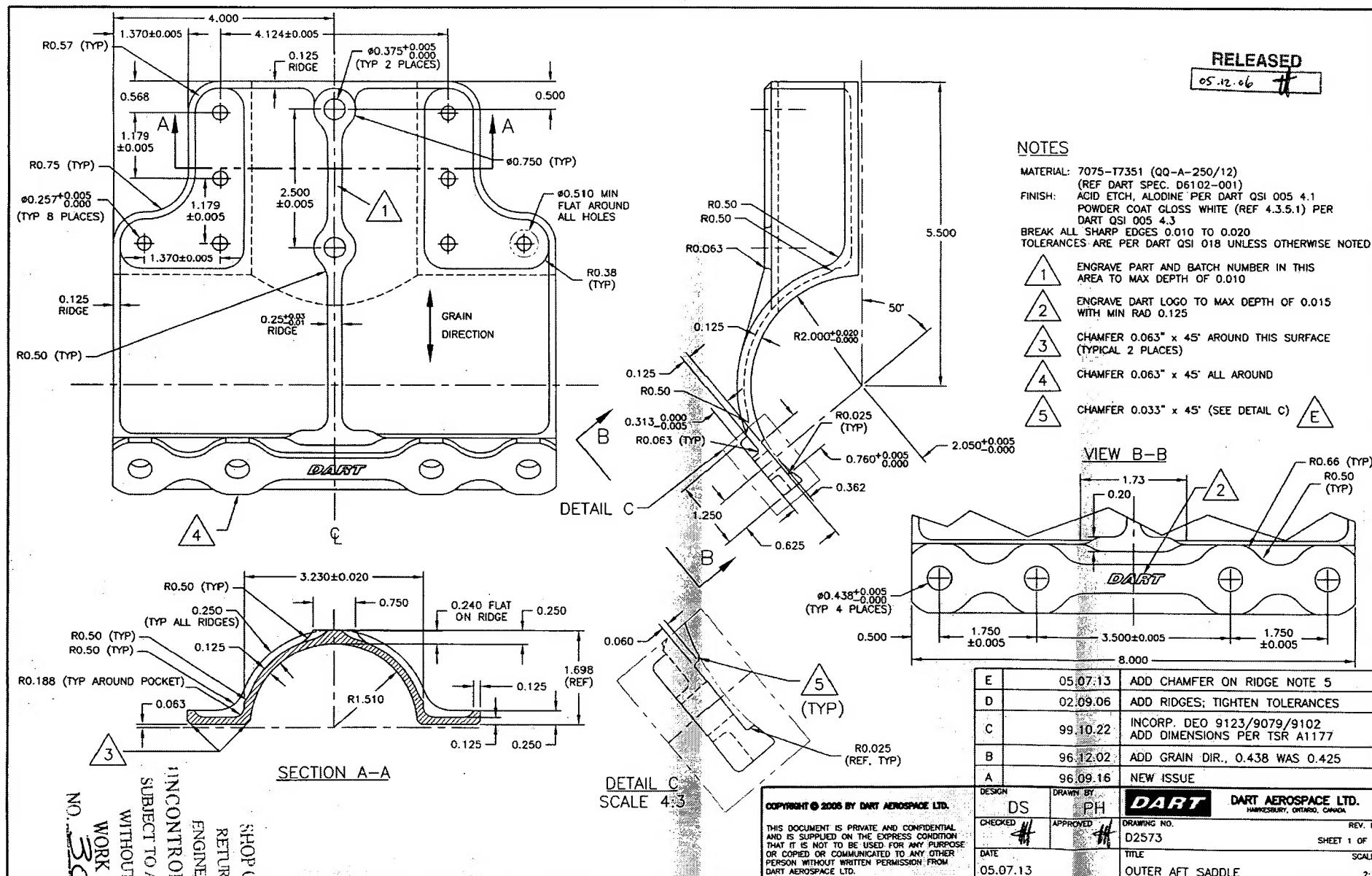
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	.438	.438	.438	.438		
B	1.745	1.755		1.755	1.755	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.755	1.755	1.755	1.755		
E	7.990	8.010		8.002	8.002	8.002	8.002		
F	0.490	0.510		.501	.501	.501	.501		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.376	.376		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.180	1.180		
K	0.558	0.578		.560	.560	.560	.560		
L	1.174	1.184		1.179	1.179	1.180	1.180		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.120	4.120	4.120	4.120		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.125	.125	.125	.125		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.120	.120	.120	.120		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.250	3.250	3.250	3.250		
V	0.230	0.250		.245	.245	.244	.244		
W	0.115	0.135		.120	.120	.120	.125		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.750	.750	.750	.750		
Z	0.352	0.372		.360	.360	.360	.360		
AA	0.470	0.530		.470	.470	.470	.470		
AB	0.615	0.635		.620	.621	.621	.621		
AC	0.053	0.073		.070	.070	.070	.070		
AD	0.240	0.260		.250	.251	.260	.260		
AE	1.500	1.520		1.511"	1.512"	1.501	1.511		
AF	0.115	0.135		.120	.120	.122	.122		
AG	0.240	0.280		.250	.251	.251	.251		
AH	0.240	0.260		.250	.245	.245	.246		
AI	2.000	2.020		2.002"	2.001"	2.001	2.001		
AJ	0.023	0.043		.033	.037	.037	.036		

Accept/Reject

Measured by:	J.F. 185	Audited by:	mk
Date:	02/01/21	Date:	07/01/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	2021





NO. 30214
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WORK ORDER
ENGINEERING
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